

Work Order ID 126489

Monday, November 10, 2014 2:03:34 PM

126489

Page 1

Item ID: D4541-1 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Bracket
Start Date: 11/10/2014 Start Qty: 8.00 ***8*** Cust Item ID:
Required Date: 11/10/2014 Req'd Qty: 8.00 ***8*** Customer:
Reference:

Approvals: Process Plan: MLS Date: 11-11-10 Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D4541	E

100		0.00							
100									
Waterjet	Memo	0.00							
FLOW CNC Waterjet	1- Cut as per dwg								
	Prog rev: <u>E</u>								
	Dwg rev: <u>E</u>								
	2- Deburr								
110	QC2- Inspect parts off machine FAI/FAIB	0.00							
110									
QC	Memo	0.00							
Quality Control									

DAS
23
9-89

DAS
23
9-89

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width: 100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Crosstube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge	☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
144	Chemical Conversion Coat per QSI005 4.1	0.00							
144									
HandFinish	Memo	0.00							
Hand Finishing									
147	QC7-Inspect Chemical Conversion Coat	0.00							
147									
QC	Memo	0.00							
Quality Control									
150	Identify as per dwg & Stock Location: <u>St626</u>	0.00							
150									
Packaging	Memo	0.00							
Packaging									

8x 8x 8x 14/12/16

8x DAS 38 9-89 DEC 16 2014

8 DEC 19 2014 DAS 36 9-89

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Work Order ID 126489

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Item ID: D4541-1

Accept

N900040100Setup Start ***NS1***

Revision ID:

Item Name: Bracket

Stop ***NS2***

Start Date: 11/10/2014 Start Qty: 8.00

8

Cust Item ID:

Required Date: 11/10/2014 Req'd Qty: 8.00

8

Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start ***NR1***

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC21- Final Inspection - Work Order Release

0.00

160

QC

Memo

0.00

Quality Control

15/1/15

AP 12-19

DQA: _____ Date: _____

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Picklist Print

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Page 1

Work Order ID: 126489

126489

Parent Item: D4541-1

D4541-1

Parent Item Name: Bracket

Start Date: 11/10/2014

Required Date: 11/10/2014

Start Qty: 8.00

Required Qty: 8.00

Comments: IPP revA 12.01.04 New Issue EC verified by:DD IPP REV:B
12.02.24 as per dwg revb DD verf:EC IPP REV:C 12.05.08 as
per dwg revC DD verf:EC IPP REV:D 13.04.23 as per dwg
revD DD verf:JLM IPP REV:E 14.03.24 as per dwg revPE2 DD
verf:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M6061T6S.032

Purchased

No

100

sf

300.0774

0.416

4

DAS
23
9-89

**

DEC 14 / 11 / 29

M6061T6S 032

6061-T6 Sheet 0.032"

Location

Loc Qty

Loc Code

MAT021

300.0774

m129257

23.35

m130387

103.7274

m130585

173

8.0555

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

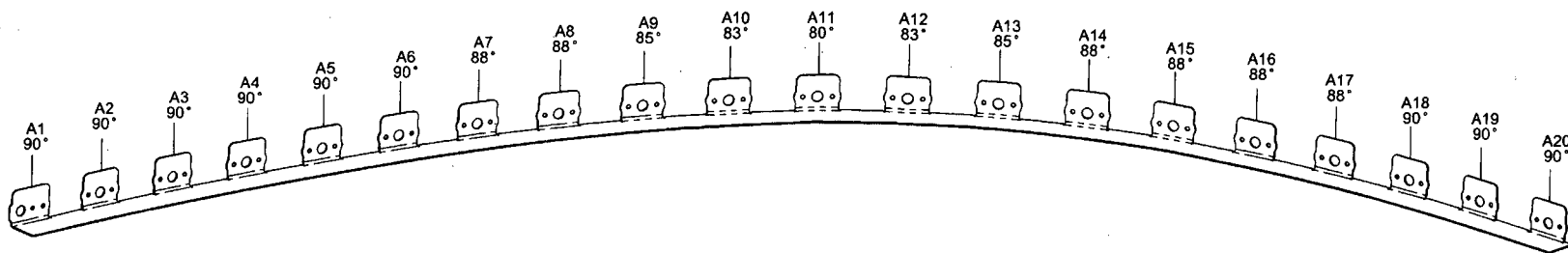
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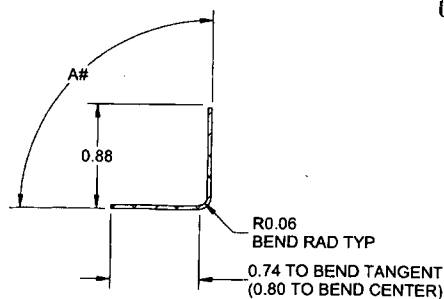
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D4541-1 BRACKET



SHOT
REF
ENGINEER
UNCONTROLLED
SUBJECT TO
WITH
WORK

NO 126489 MJS

14-11-10

RELEASED
2014-03-26

NOTES:

- 1) MATERIAL: MAKE FROM D4541-1F
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: DART P/N & B/N PER DART QSI 044 6.1
- 7) WEIGHT: 0.15 lbs
- 8) BEND INDIVIDUAL TABS ON D4541-X BRACKETS TO CORRESPONDING "A#" (A1, A2, ETC.,) VALUE

E	ADDED -1 & -2 BENT. SHT 2 & 4 ZN C6 0.80 DIM WAS 0.60. SHT 10 ZN C7 & C4 1.75 DIM WAS 1.55 -5 & -6 UPDATED ACCORDINGLY. SHT 13 ZN C8 2.5 DIM WAS 2.3, 1.66 DIM WAS 1.48 -7 & -8 UPDATED ACCORDINGLY.	AJS	14.03.07
D	ADD BENT SHAPES -3/-4/-7/-8	CP	13.02.04
C	D4541-5F WAS -5; ADD -5/-6; RMV FINISH (-1/-2/-3/-5F/-7); 0.70 WAS 0.60 (ZN D1-3)	CP	12.04.20
B	-5: 1.55 WAS 1.45 (ZN C4-4)	CP	12.02.01
A	NEW ISSUE	CP	12.01.09
REV.	DESCRIPTION	BY	DATE
DESIGN	CP		
DRAWN	AJS		
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	14.03.07		
DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D4541 TITLE BRACKET REV. E SHEET 1 OF 13 SCALE NTS COPYRIGHT © 2012 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL. IT IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.			

